# MULTI-STAGE PROCESSES FOR COATING SUBSTRATES WITH MULTI-COMPONENT COMPOSITE COATING COMPOSITIONS

## Abstract of the Disclosure

A process for coating a substrate is provided which includes the following steps:

(a) applying a waterborne base coat composition to a surface of the substrate;

(b) applying infrared radiation at a power density of 1.5-30.0 $kW/m^2$ and a first air stream simultaneously to the base coat composition such that a pre-dried base coat is formed upon the surface of the substrate; and

(c) applying a second air stream in the absence of infrared radiation to the base coat composition such that a dried base coat is formed upon the surface of the substrate.

Various embodiments of the invention are disclosed including continuous, batch, and semi-batch processes, which may include additional process steps, such as subsequent application of a topcoat. The process may be used to coat a variety of metal and polymeric substrates, for example, those associated with the body of a motor vehicle.